

Work Order ID 163092

Wednesday, June 21, 2017 11:45:10 AM

163092

Page 1

Item ID: D5326-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly
Start Date: 7/5/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/10/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:
Approvals: Process Plan:  Date: JUN 21 2017 Tooling: Date:
QC: Date: SPC (Y/N): Date:
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5326	A								

100 Weld per dwg A/R S.S. rod Batch: **4135068** 0.00
100
Large Fab Memo 0.00
Large Fab 1- Cut D5326-3 as per dwg
2- Drill holes as per dwg D5332 using DT10195
3- Remove identification marks and deburr
4- Weld bushing and end cap in rib as per dwg and grind flush

110 QC10- Inspect visual per QSI004- ground welds 0.00
110
QC Memo 0.00
Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
120
QC Memo 0.00
Quality Control

3A D.M.L. 2017-06-28
3x **DAS 43 9-89 JUL 03 2017**

DAS 24 9-89 JUL 03 2017 3

DAS 24 9-89 JUL 03 2017 3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
THIS E.O. JUL				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Page 2

Item ID: D5326-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib Assembly

Start Date: 7/5/2017 Start Qty: 1.00

1*3
1

Cust Item ID:

Required Date: 7/10/2017 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WVA

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

3xDAS
43
9-89

JUL 03 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

17/7/4 AD

JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																									

Picklist Print

Wednesday, June 21, 2017 11:45:10 AM

Page 1

Work Order ID: 163092

163092

Parent Item: D5326-043

D5326-043

Parent Item Name: Rib Assembly

Start Date: 7/5/2017

Required Date: 7/10/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5327-15

Manufactured

No

100

Each

18.0000

1

1

DAS

43

9-89

JUL 03 2017

✓ *D5327-15*

Cap

**B161209 → 3x

Location

Loc Qty

Loc Code

WA004

18

161209

18

D5338-1

Manufactured

No

100

Each

47.0000

2

2

DAS

43

9-89

JUL 03 2017

✓ *D5338-1*

Bushing

**B159843 → 6x

Location

Loc Qty

Loc Code

WA004

47

159303

17

159843

30

M304TS0.500W.049

Purchased

No

100

f

359.7068

1.8

1.894737

✓ *M304TS0 500W 049*

Square Tubing

**

D.M.L.-2017-06-28

Location

Loc Qty

Loc Code

WA004

359.70684

M135215

31.06

M136011

21.64684

M137257

307

DQA: _____ Date: _____



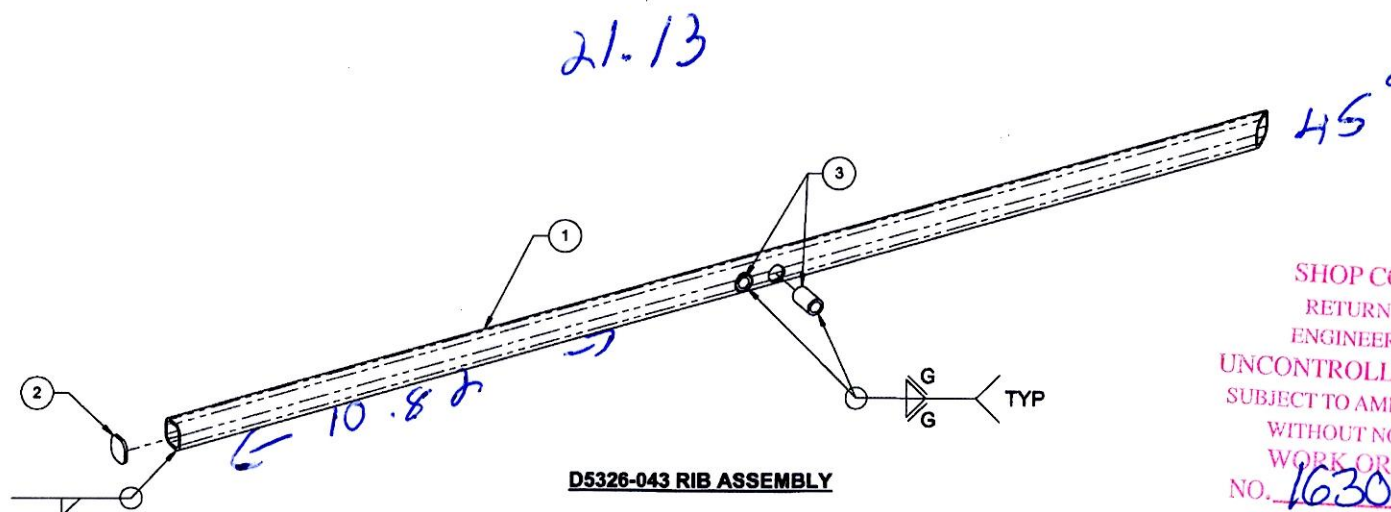
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5326-043	RIB ASSEMBLY
1	1	D5326-3	RIB
2	1	D5327-15	CAP
3	2	D5338-1	BUSHING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163002

JUN 21 2017

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.8
7) WEIGHT: 0.47 lbs
8) WELD PER QSI 004

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5326	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	RIB ASSEMBLY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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